

must ship July 30

Work Order ID 60783

Thursday, July 22, 2010 1:32:16 PM



Page 1

Item ID: D4150-1

Accept



Setup Start



Revision ID:

Item Name: Arm

Stop



Start Date: 7/22/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date: 10-7-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4150	PAI <i>B</i>								
100	Cut blanks as per folio	0.00							
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	3.950" LONG								
110		0.00							
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	MACHINE AS PER FOLIO FA943 AND DWG								
	FOLIO REV: <i>HT</i>								
	DWG REV: <i>15</i>								
	DEBURR								

mj
10/07/23

S.P 10/07/26

up 10-7-24

4 *X*

(4) *X*

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4150-1 PAR #: _____ Fault Category: production - correct NCR: Yes No DQA: [Signature] Date: 10/7/27
 Resolution: _____ Disposition: _____ QA: N/C Closed: [Signature] Date: 10/07/28

NCR: <u>60783</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/07/25	110	PROGRAM ERROR. SHOULD ONLY HAVE TOLD HOLDS - OLD PROGRAM HAS 3 NOLES. EC: LOA.	MP 10/07/26	SCRAP - REDUCE QTY 1 Some Batch 1115047 SP 10/07/25	MP SP 10/07/25	E.A 10/07/27	[Signature]	[Signature] 10/07/27

NOTE: Date & initial all entries

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Item Name: Arm

Start Date: 7/22/2010 Start Qty: 4.00

Required Date: 7/29/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60783

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Accept

Setup Start

Revision ID:

Stop

Item Name: Arm

Start Date: 7/22/2010 Start Qty: 4.00

Required Date: 7/29/2010 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/28 J
10-7-27
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 22, 2010 1:32:23 PM

Page 1

Work Order ID: 60783

Parent Item: D4150-1

Parent Item Name: Arm



Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B0.750X1.500		Purchased	No			100	f	43.4567	0.333333	1.333332			
303 BAR .750" X 1.500"													

Location

MAT
115047
MAT53
114968

Loc Qty

24
24
19.45666
19.45666

Loc Code

must 10/07/25 1.3825 - ~~1.3825~~ 25 10/07/25

→ 1.3825 too replace 4 parts
Scrap.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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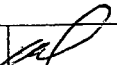
NOTE: Date & initial all entries

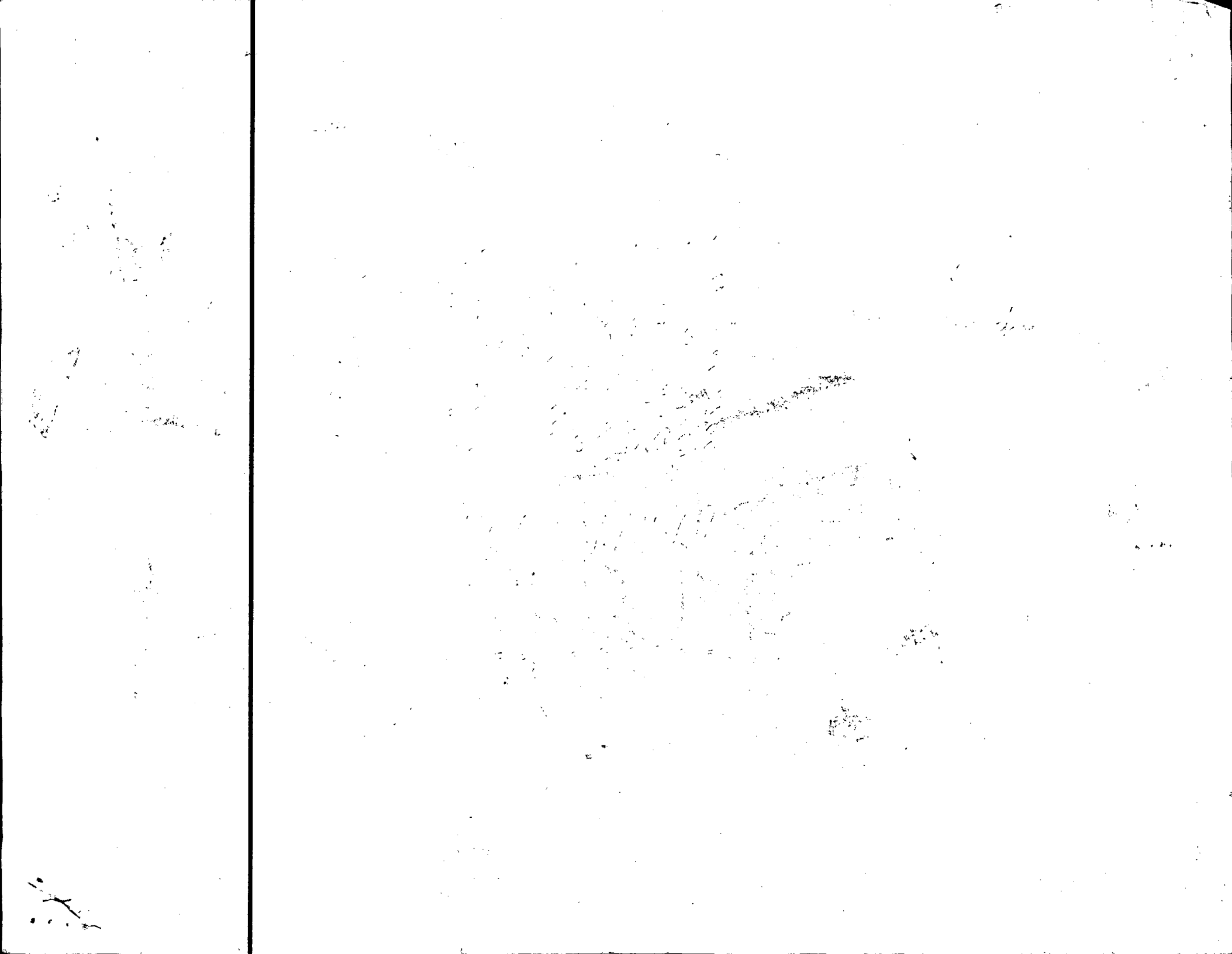
DART AEROSPACE LTD		Work Order: 60783
Description:		Part Number:
Inspection Dwg:	Rev: B	Page 1 of 1

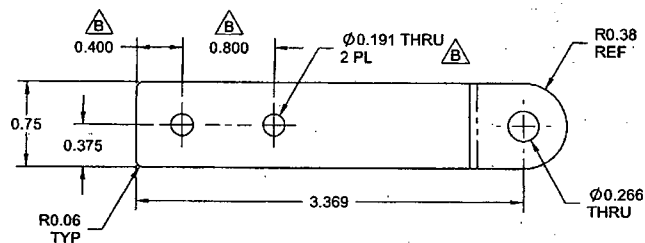
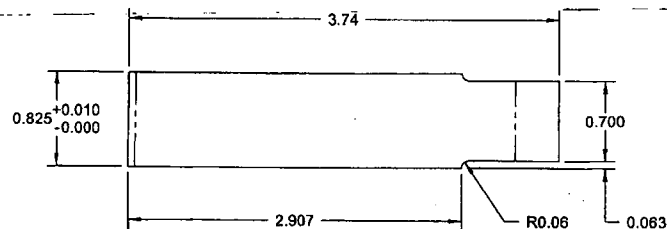
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.74	+/- .030	3.745	/		Vern.	
.825	+ .01 - 0.0	.830	/		"	
.700	+/- .010	.706	/		"	
2.06	+/- .030	2.05	/		"	
.063	+/- .010	.063	/		"	
2.907	+/- .010	2.907	/		"	
.400	+/- .010	.400	/		"	
.800	+/- .010	.800	/		"	
.191	+ .005 - .001	.191	/		"	
2.38	+/- .030	2.370	/		"	
.75	+/- .030	.741	/		"	
.375	+/- .010	.375	/		"	
2.06	+/- .03	2.06	/		"	
3.369	+/- .010	3.369	/		"	
.256	+ .006 - .001	.270	/		"	

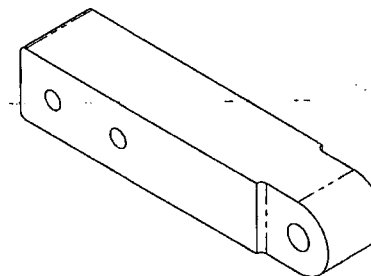
Measured by: 	Audited by: P.A.	Prototype Approval:	N/A	
Date: 10.7.24	Date: 10/07/27	Date:	N/A	
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





D4150-1 ARM

x4



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **00783**
BS10-722

RELEASED
2010-07-16
MP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4150	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		ATTACHMENT ARM ASSY	SCALE
DE APPR.			NTS
DATE	10.07.08	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSON OF DART AEROSPACE LTD.</small>	